

Date: Wednesday, 9/13/2006 4:30:40 PM  
User: Kim Johnston

Process Sheet

Split  
SB 06/10/05

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EYEBALL ADAPTER
Job Number	: 28528	Part Number	: D3480041
Estimate Number	: 12246	Drawing Number	: D3480 REV.A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/13/2006	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 10/6/2006
Previous Run	: 26959	Type	: SMALL /MED FAB
Written By	: _____	Qty:	4 Um: Each
Checked & Approved By	: _____		
Comment	: est rev. A 06.02.07 new issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 D34805 EYEBALL ADAPTER FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-5	Flange	B 28576

2.0 D34803 tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-3	Tube	B 28575

SB 06/10/10

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as.per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

MF 06/10/10 (2) (2)

4.0 QC5/11 INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

SB 06/10/10 (2)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 28528

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location:

57444

RB 06/10/10

(2)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

RB 06/10/11

Job Completion



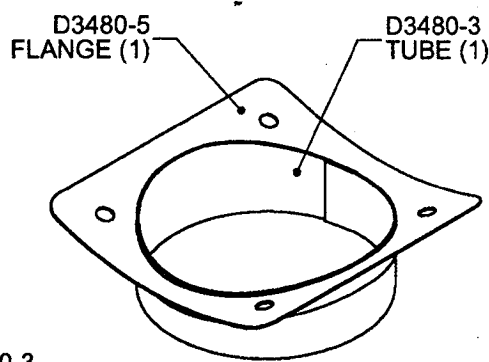
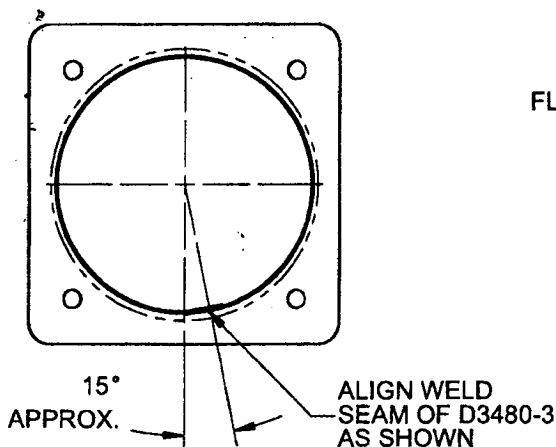
W To 10/11



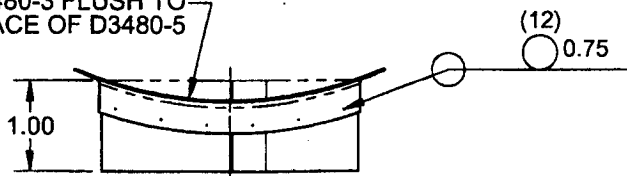
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. A SHEET 1 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	

*[Signature]* 06.04.03

UNDER REVIEW  
06.05.17 *[Signature]*



SPOT WELD PARTS. THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### D3480-041 EYEBALL INLET ADAPTER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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NO. 31

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Melanie Boucher  
Joint Welding Procedure Spot Welding  
Part number and Job number D 3480-041 B 28528

TEST WELDS REQUIRED

BASE METAL 304 26G WELDING PROCESS Spot  
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒ ✓

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

*N/A*

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐ *N/A*

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/10 Qualifier Sylvie Boucher